

PO-12-005162
Cagle order

Work Order ID 93524

November 19, 2012 10:07:29 AM

93524

PRELIMINARY

Page 1

Item ID: D4714-1

Revision ID: PRELIM

Item Name: Channel

Start Date: 11/19/12

Start Qty: 1.00

1

Required Date: 11/23/12

Req'd Qty: 1.00

1

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: *CX*

Date: 12/11/19

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Work Center ID	Operation Description	Setup/Run Hours	ID	Tool	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4714	pal								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
304.050	Dwg Rev: <i>PA1</i>								
	Prog Rev: <i>PA1</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
15
2-09

12/11/20

2
inspect as per
Dwg PA1

2

12/11/19

2

12/11/19

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 93524

93524

Page 2

November 19, 2012 10:07:29 AM

Item ID: D4714-1

Accept

N900040100

Setup Start ***NS1***

Revision ID: PRELIM

Stop ***NS2***

Item Name: Channel

Start Date: 11/19/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/23/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence	Operation Description	Set Up/Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
----------	-----------------------	------------------	---------	--------	-----------	------------	------------	---------------	-------------

130 Form as per dwg
NC BRAKE

0.00

130

Brake NC

Memo

0.00

Brake NC

140 QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150 Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

Part is per Pat Dwg.
02/11/13

SP
12/11/12

DAS
15
289
12/11/21

1

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: <u>D4714-1</u> Part No. <u>893524</u> NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input checked="" type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data	12/4/21	130	1	Use 1 for test bend		Scrap & destroy Noneplace	Sh 12/4/21				
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input checked="" type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other <div style="text-align: center; margin-top: 10px;"> <u>Use for test bend</u> </div>

Work Order ID 93524

November 19, 2012 10:07:29 AM

93524

Page 3

Item ID: D4714-1

Accept

N900040100Setup Start ***NS1***

Revision ID: PRELIM

Stop ***NS2***

Item Name: Channel

Start Date: 11/19/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/23/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13594
POSITIVE RECALLEFFECTIVE 12-11-19 AUTH W

RELEASED _____ DATE _____

MF
12-11-20

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge _____ _____ _____	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

November 19, 2012 10:07:28 AM

Page 1

Work Order ID: 93524

Parent Item: D4714-1

Parent Item Name: Channel

Start Date: 11/19/12

Required Date: 11/23/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.08.30 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 304/316 .050 Sheet		Purchased	No			100	sf	163.8149	0.5162	0.5433684		12-11-19	

Location

Loc Qty

Loc Code

MAT020

163.814947

121626

1.65

121660

1.000737

123155

45.56421

123279

31.4

123372

19.2

123649

55

123649

NCR: Yes / No

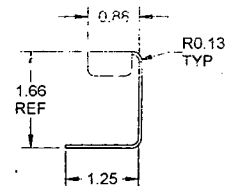
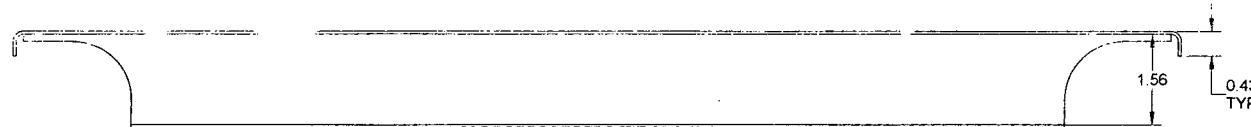
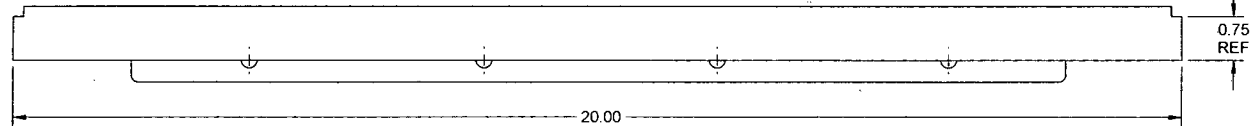
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



D4714-1 CHANNEL

CL 1211119
W/O: 93524

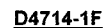
PRELIMINARY ISSUE

12.08.27

NOTES:


- 1) MATERIAL: MADE FROM D4714-1F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.90 lbs

PA1	NEW ISSUE	BY	12.08.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.08.27		
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO. D4714	REV. PA1
		TITLE CHANNEL	SCALE NTS
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12.08.27

2) FINISH: ANNEALD 2B FINISH
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.90 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4714	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	CHANNEL	NTS	
DATE	12.08.27	COPYRIGHT © 2012 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATELY CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Receiving Report

Date: 12/11/82
 Supplier: T.H. 506h

Batch No: M/23649
 Dart P/O: 18348

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection: 14 12/11/82 N/A ☒
 Work Order: 9-83 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M2024T35.63		192	0	0	192	
M6061T65-032		192	0	0	192	
M303B1-00V2-00		12	0	0	12	

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 12/11/82
 Date: [Signature]
 Received/Costing: [Signature]
 Initial: [Signature]

Location _____

Purchase Order Receipt Listing

Page 1 of 2

Monday, November 12, 2012 10:38:24 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO18348 Receipt Dates from 11/12/2012 to 11/12/2012 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ Reject Qty	Book Amt
VendorID/Vendor Name		VC-COP001 Thyssenkrupp Materials CA Ltd									
PO18348	2		M304S18GA	sf	11/14/2012	11/12/2012	192.0000	\$3.39	0.0000	0	\$650.15
CAD	No		304/316 .050 Sheet	sf	192.0000	DESJ02		\$650.15	0.0000	0	
			123649								
	4		M6061T6B2.000X01. f		11/14/2012	11/12/2012	36.0000	\$6.01	0.0000	0	\$216.22
			250								
	No		6061-T6 Bar 2.00 x	f	36.0000	DESJ02		\$216.22	0.0000	0	
			1.25								
			123649								
	5		M6061T6B1.000X12. f		11/14/2012	11/12/2012	12.5000	\$28.36	0.0000	0	\$354.52
			000								
	No		6061-T6 Bar 1.00 x	f	12.0000	DESJ02		\$354.52	0.0000	0	
			12.00								
			123649								
	6		M6061T6B1.250X01. f		11/14/2012	11/12/2012	12.0000	\$3.67	0.0000	0	\$44.05
			250								
	No		6061-T6 Bar 1.25 x	f	12.0000	DESJ02		\$44.05	0.0000	0	
			1.25								
			123649								
	7		M6061T6B1.500X01. f		11/14/2012	11/12/2012	12.0000	\$4.55	0.0000	0	\$54.65
			250								
	No		6061-T6 Bar 1.50 x	f	12.0000	DESJ02		\$54.65	0.0000	0	
			1.25								
			123649								
	8		M6061T6B2.500X03. f		11/14/2012	11/12/2012	12.0000	\$20.68	0.0000	0	\$248.17
			500								
	No		6061-T6 Bar 2.50 x	f	12.0000	DESJ02		\$248.17	0.0000	0	
			3.50								
			123649								
	10		M304B0.250X4.000 f		11/14/2012	11/12/2012	24.0000	\$7.49	0.0000	0	\$179.70
			304 BAR .250 x 4.00	f	24.0000	DESJ02		\$179.70	0.0000	0	
	No		123649								

LC

39

B I L L O F L A D I N G

Ship From: THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 905-738-9033

No: PEC 794557
Ship Date 09Nov12 at 13:43 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

444

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

B I L L O F L A D I N G

1) Our Order PEC-507930- 1 Your PO # 18348

STAINLESS STEEL SHEET 304-2B

.0480 Nom X 48.0000" X 96.0000"

Heat Number
300725

Tag No
123096

Quantity
192.00 SFT

PCS
6

Wt LBS
364

2) Our Order PEC-507930- 2 Your PO # 18348

ALUMINUM FLAT BAR 6061-T6511

1.250" x 2.00" X 144.0000"

Heat Number
2BR820

Tag No
123049

Quantity
36 FT

PCS
3

Wt LBS
106

3) Our Order PEC-507930- 3 Your PO # 18348

ALUMINUM FLAT BAR ECONOPLT 6061-T6511

1.00" X 12.00" X 144.5000"

Heat Number
Z00014033

Tag No
123050

Quantity
12 .5000 "

PCS
1

Wt LBS
171

4) Our Order PEC-507930- 4 Your PO # 18348

Part # STOCKED

ALUMINUM SQUARE BAR 6061-T6511

1.250" X 144.0000"

Heat Number
Z00240020

Tag No
123051

Quantity
12 FT

PCS
1

Wt LBS
23

5) Our Order PEC-507930- 5 Your PO # 18348

ALUMINUM FLAT BAR 6061-T6511

1.250" x 1.50" X 144.0000"

Heat Number

Tag No

Quantity

PCS

Wt LBS

Page: 1Continued

1-Skip

1-BDL

F 6.0

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT

ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY

RETOUR DE MARCHANDISES AVEC NOTRE NUMÉRO D'APPROBATION SEULEMENT
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER

THYSSENKRUPP MATERIALS NA

DART AEROSPACE

STAINLESS STEEL SHEET 304-2B
 .0480 Nom X 48.0000" X 96.0000"
 PART NO.

PO/Rel 18348

We certify that this is a true copy of the report
 furnished by the producer of the metal, or data
 resulting from tests made in approved labs.


Certificate of Mill Test Results

BL PEC-794557-001

9Nov12

Signed by:

Pg 1/1

 <p>ThyssenKrupp</p>		<p>Type of document / Tipo de documento / Art der Prüfungsbescheinigung</p> <p>INSPECTION CERTIFICATE CERTIFICADO DE INSPECCION ABNAHMEPRÜFZEUGNIS</p> <p>according to / de acuerdo con / nach EN 10204-3.1</p>		<p>Document number / Nº de certificado / Bescheinigungs-Nr.</p> <p>0000025813 /</p> <p>Page / Página / Seite:</p> <p>1 / 1</p>																	
<p>1 ThyssenKrupp Drive, P.O. Box 13000, Calvert, AL 36513-1300</p> <p>OLBERT METALS SALES LIMITED 989 DERRY ROAD EAST SUITE 305 MISSISSAUGA ON L5T 2J8 CANADA</p>		<p>Customer/Ship to / Cliente / Empfänger/Implanter</p> <p>OLBERT METALS SALES LIMITED, MISSISSAUGA</p> <p>Customer's order number / Nº de Pedido Cliente / Kundenbestellung</p> <p>TO-1628</p> <p>Manufacturer's work order no. / Nº de Pedido Manufactura / Werksauftragsw.</p> <p>001145653 / 007</p> <p>Delivery date no. / Nº de Entrega / Lieferungsange Nr.</p> <p>B5218320 / 070</p> <p>Product / Producto / Bauelement</p> <p>SHEET/HOJAS/BLECH</p> <p>Steel grade and quality / Acero / Stahlgüte und Gütegruppe</p> <p>TYPE 304L/304</p>																			
<p>Terms of delivery / Condiciones de entrega / Lieferbedingungen</p> <p>ASTM A240/A240M, ASME SA-240 Sec.II Part A Ed.2010 ASTM A480/A480M, ASME SA-480 Sec.II Part A Ed.2010</p>		<p>Product dimensions (Thickness / Width / Length) / Dimensiones (Espesor / Ancho / Largo) / Maße des Erzeugnisses (Dicke / Breite / Länge)</p> <p>1.22 min x 1,218.20 mm x 2,438.40 mm 0.0480 inch x 48.0000 inch x 96.0000 inch</p> <p>Surface treatment / Tratamiento superficial / Oberflächenbehandlung</p> <p>AOD</p> <p>Finish / Acabado / Aufbereitung</p> <p>116 / 28</p>																			
<p>Customer's material no. / Nº de material del cliente / Kundenmaterial-Nr.</p> <p>6033088</p>		<p>Weight / Peso / Gewicht</p> <p>4,467 lb / 2,026 kg</p>		<p>Coil No. / Bobina No. / Blatt-Nr.</p> <p>709255</p>																	
<p>Sheet / Hoja / Blatt</p> <p>74</p>		<p>Sample No. / Nº de muestra / Proben-Nr.</p> <p>1000044779</p>		<p>Sample No. / Nº de muestra / Proben-Nr.</p> <p>1000044780</p>																	
<p>Heat / Coiled / Schmelze</p> <p>30U725</p>		<p>Chemical composition / Composicion Quimica / Chemische Zusammensetzung</p> <table border="1"> <thead> <tr> <th>% C</th> <th>% Si</th> <th>% Mn</th> <th>% P</th> <th>% S</th> <th>% Cr</th> <th>% Ni</th> <th>% N</th> </tr> </thead> <tbody> <tr> <td>0.029</td> <td>0.30</td> <td>1.84</td> <td>0.029</td> <td>0.0010</td> <td>18.14</td> <td>8.04</td> <td>0.062</td> </tr> </tbody> </table>				% C	% Si	% Mn	% P	% S	% Cr	% Ni	% N	0.029	0.30	1.84	0.029	0.0010	18.14	8.04	0.062
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<p>Sample Position / Localiz. de la muestra / Probenlage</p> <p>TRANSVERSE</p>		<p>Inspection ref. / Referencia de inspección / Prüf-Nr.</p> <table border="1"> <thead> <tr> <th>YS 0.2%</th> <th>TS</th> <th>EL A2*</th> <th>HRB</th> </tr> <tr> <th>PSI / MPa</th> <th>PSI / MPa</th> <th>%</th> <th></th> </tr> </thead> <tbody> <tr> <td>41,914 / 289</td> <td>91,950 / 634</td> <td>58</td> <td>82</td> </tr> <tr> <td>40,174 / 277</td> <td>91,805 / 633</td> <td>57.5</td> <td>81</td> </tr> </tbody> </table>				YS 0.2%	TS	EL A2*	HRB	PSI / MPa	PSI / MPa	%		41,914 / 289	91,950 / 634	58	82	40,174 / 277	91,805 / 633	57.5	81
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<p>Test of identity (Spectrometry analysis) / Control de identidad (análisis espectroscópico) / Verwechslungsprüfung (Spektroskopische Identifizierung)</p> <p>OK</p>		<p>Test of identity (Spectrometry analysis) / Control de identidad (análisis espectroscópico) / Verwechslungsprüfung (Spektroskopische Identifizierung)</p> <p>OK</p>																			
<p>No weld repairs</p> <p>No intentional additions of Mercury compounds were made or used</p> <p>Free of radioactive contamination</p> <p>EU RoHS Directive 2002/95/EC Compliant</p> <p>Country of Heat as per ISO 3166-1</p>																					
<p>Originator of the document / Origenador del documento / Aussteller der Bescheinigung</p> <p>ThyssenKrupp Stainless USA, LLC</p> <p>An ISO 9001:2008 certified company</p>		<p>The information provided is a true copy of data on file / Los valores mostrados corresponden a los datos archivados / Die behaupteten Werte entsprechen den gespeicherten Daten</p> <p><i>Andrew Faucett</i> Andrew Faucett Phone: +1 261 829 3492</p> <p>Date of issue and validation / Fecha de emisión y validación / Datum Ausstellung / Gültigkeitsangabe</p> <p>10/03/2012</p>																			

DAS
 14
 2-89



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18348**

Purchase Order Date 11/07/12

PO Print Date 11/07/12

Page Number 1 of 4

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Contact Name

Vendor Phone

905 669 9444

Vendor Fax

905 738 9033

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
C212/11/12

m123699

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6S.032	6061-T6 Sheet 0.032"	11/14/12 Yes	192.00 sf	Yours ppd	\$2.1875	\$420.00
		Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/11 OR AMS-QQ-A- 250/11 OR AMS 4025 OR AMS 40327 OR ASTM B209					
2	M304S18GA	304/316 .050 Sheet	11/14/12 Yes	192.00 sf	Yours ppd	\$3.3828	\$649.50
		Special Inst: MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH AS MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240					
3	M2024T3S.063	2024-T3 .063 sheet	11/14/12 Yes	192.00 sf	Yours ppd	\$5.8521	\$1,123.60

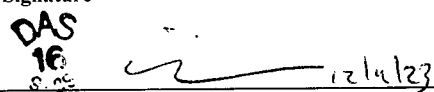
**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

PO Instructions: QUOTE : # PEC ST-506619

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

Change Nbr: 1

Change Date: 11/07/12

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE Form One			3. Form Tracking Number: ED-2012-11-23-1	
4. Organizations Name and Address: Dart Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario, K6A 1K7, CANADA Tel: 1 (613) 632-5200 Fax: 1 (613) 632-5246 www.dartaero.com					5. Work Order/Contract/Invoice Work Order 93524	
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial/Batch Number:	11. Status/Work:	
1	Channel	D4714-1	1	B93524	PROTOTYPE	
12. Remarks: <p>"NOT ELIGIBLE FOR INSTALLATION ON IS-SERVICE TYPE CERTIFIED AIRCRAFT"</p> <p>"THIS ITEM CONFORMS TO DATA THAT IS NOT APPROVED AT THE TIME OF RELEASE, SUBJECT TO APPROVAL OF THE DATA, THE ITEM IS IN CONDITION FOR SAFE OPERATION."</p>						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input checked="" type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12, has been performed in compliance with the <i>Canadian Aviation Regulations</i> .			
13b. Signature 		13c. Approval Organization Number 9-89		14b. Signature		14c. Approved Organization Number
13d. Name Eric Downing		13e. Date (dd/mm/yyyy): 23/Nov/2012		14d. Name		14e. Date (dd/mm/yyyy):
30 Dec 2008(Previously form 24-0078)						
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than the authority specified in Block 1, must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements 13a or 14a do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						